



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SOLD
FEB 10

D4910-1
Job Sheet 171038



Part No: D4910-1

Job Qty: 12 ea

Part Name: Chaffing Shield



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 2/9/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.08.21 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/8/18	0.00	0.00	Start Up Waterjet		18/01/31 SC
100	Waterjet	12 pcs		2/8/18	0.03	0.77	Waterjet1		18/01/31 SC
110	QC	12 pcs		2/8/18	0.00	0.00	QC2 Waterjet-1		18/01/31 SC
120	QC	12 pcs		2/8/18	0.00	0.00	QC8-5		38
130	Small Fab	12 pcs		2/9/18	0.00	1.18	Small Fab-8		38 FF
140	QC	12 pcs		2/9/18	0.00	0.00	QC5		38
150	Packaging	12 pcs		2/9/18	0.00	0.00	Packaging3		9-88
160	QC21-SA	12 Ea		2/9/18	0.00	0.00	QC21		38

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S25GA	304/316 .020" Sheet 304 Sheet 25 Ga	4.2000 sf (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S25GA 24 ea	4 4.5	0	0

Part Specifications

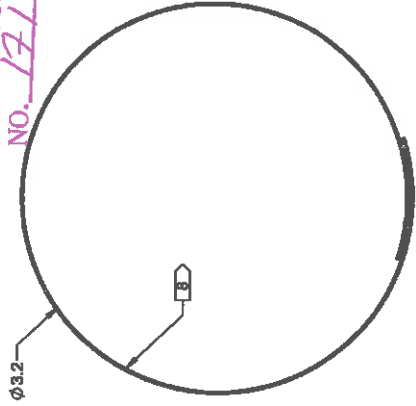
Specifications could not be found.

Plex 1/26/18 7:33 AM dart.lacelle.linda

see attach sheet at back.

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WITHOUT NOTICE

WORK ORDER
NO. 17103845
180126



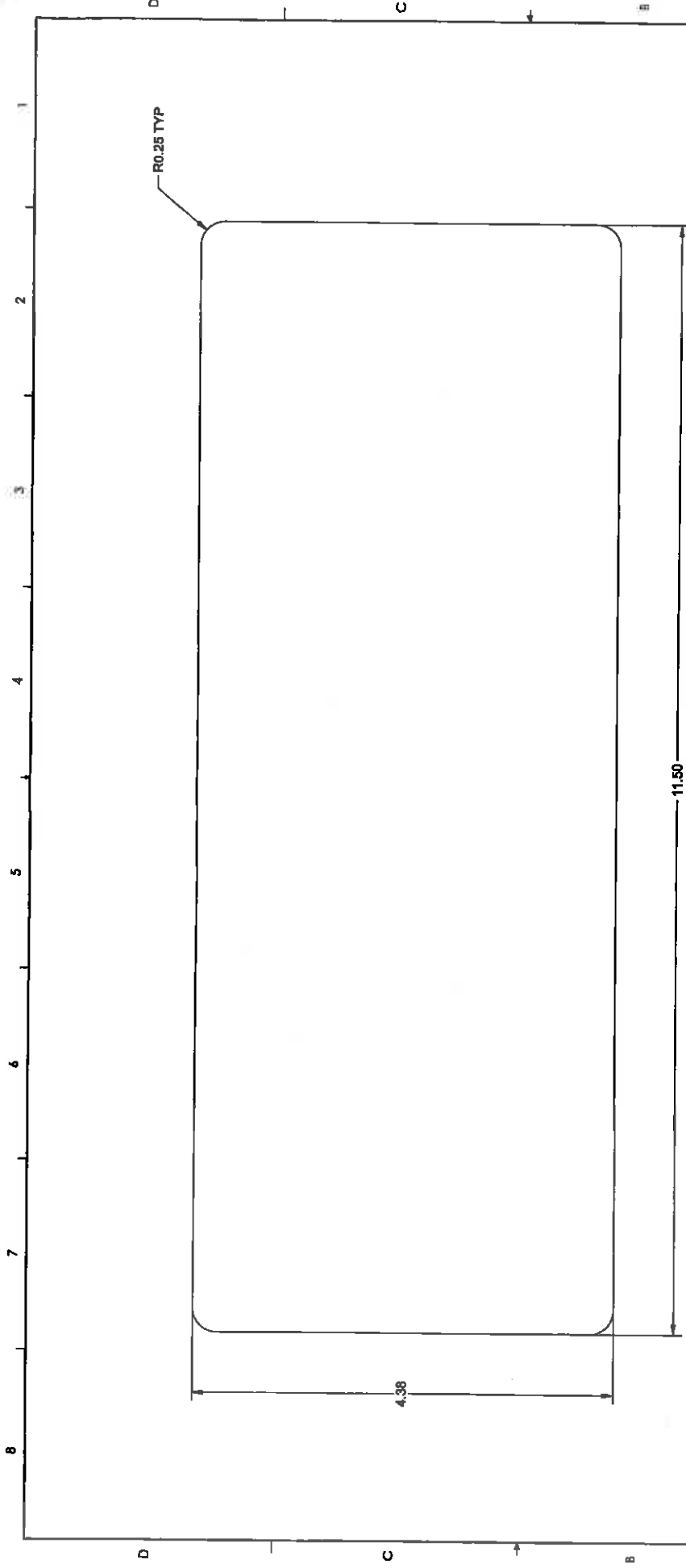
4.38 REF

D4910-1 CHAFING SHIELD

RELEASED
R 2013-08-14

- NOTES:
- 1) MATERIAL: MAKE FROM D4910-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs
 - 8) APPLY A THIN COAT OF PROSEAL 880 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS.

A		NEW ISSUE		DESCRIPTION		CP	BY	DATE
REV.								
DESIGN								
DRAWN								
CHECKED								
MFG. APPR.								
APPROVED								
DE APPR.								
DATE								



D4910-1F FLAT PATTERN

RELEASED
2013-08-14
MP

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.020 THICK, ANNEALED
PER MIL-S-2080, AMS 5513, AMS 5824, ASTM A240, OR ASME SA240
REF DART SPEC MS04S256A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.003 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA
CHECKED	MP	
MFG. APPR.	MP	DRAWING NO. D4910
APPROVED	MP	REV. A
DE APPR.	MP	SHEET 2 OF 2
DATE	13.04.24	TITLE CHAFING SHIELD
		SCALE NTS

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md 18 June 2019



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: 171038		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. 04910-1		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐			
NCR No. 19-7159		Suspected Unapproved		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐			
Date: 18/1/31		Step #:		QTY Effective:			
Description Work Order Deviation		Disposition					
25 GA material does not exist.		Acceptable to use 24GA material. PAR 14-326					
Root Cause		Completed By					
Environment: ☐ Design: ☐ Doc/Data: ☒ Equip/Tooling: ☐ Handling/Pre: ☐ Material: ☐ Internal Transport: ☐ Tribal Knowledge: ☐ LOA: ☐ Substation: ☐ Past Expiry Date: ☐ Misidentified: ☐		DAS 12 9-89 18/1/31					
No Re-verification ☐ Operator: ☐ Offset/Setup: ☐ Supplier: ☐ Training: ☐ Use for Testing: ☐ Poor Information: ☐ Rushing: ☐ Product Improvement: ☐ Process Improvement: ☐ Manufacturing Process: ☐ Past Due: ☐		Lead hand / Supervisor Approval Verification DAS 9 9-89 18-02-20					
Pressure/Forced Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		QC / QA Coordinator Approval DAS 9 9-89 18-02-20					
Temperature/Cure Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☒ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER: ☐							